



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE1120-31502W1-3

Job Sheet 185464



Part No: RBE1120-31502W1-3

Job Qty: 2 ea

Part Name: Top



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1120-31502W1 Rev.1 IPP Rev. A 18.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining		<i>Am</i> 18/12/11
110	Mori Seiki	2 pcs	11/9/18	11/9/18	0.00	4.00	MORI NV5000-1		<i>Am</i> 18/12/11
120	QC	2 pcs	11/9/18	11/9/18	0.00	0.00	QC2-2		<i>Am</i> 18/12/11
130	QC	2 pcs	11/9/18	11/9/18	0.00	0.00	QC8		<i>Am</i> 18-12-12
150	Outsource	2 pcs	11/9/18	11/9/18	0.00	0.00	Outsource13		<i>Am</i> 18-12-12
160	Packaging	2 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		<i>Am</i> DEC 18 2018
170	QC	2 pcs	11/9/18	11/9/18	0.00	0.00	QC6		<i>Am</i> 38
180	Packaging	2 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		<i>Am</i> 9-89
190	QC21-SA	2 Ea	11/9/18	11/9/18	0.00	0.00	QC21		<i>Am</i>

Part Op 110 - 1-Cut blanks to 1.35 " 2-Machine as per folio FC 456 FOLIO REV: AA DWG REV: 8 2018

Descriptions: 2-Deburr

150 - Issue P/O to GROUPE ALTECH: P/O 042028 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required

GA 133

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-B-1.250X2.500 <i>2.500X3.500</i>	Hot Rolled Steel Bar 1.250" W X 4.500" H	.2260 (.113 ea)	90-Start up Operation	<i>5082799</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-HRS-B-1.250X2.500	0	0	0

Part Specifications



Container No: S136516



Part: RBE1120-31502W1-3

Job No: 185464

Serial No/Batch: S136516

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/11/18

Specifications could not be found.

Plex 10/26/18 1:52 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

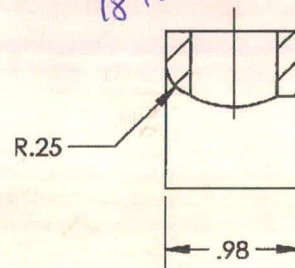
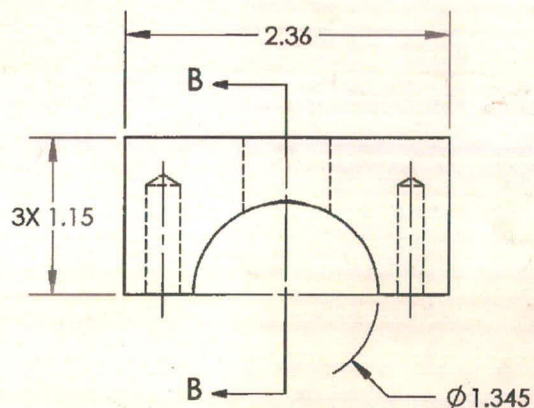
QA Closed: _____ Date: _____

Work Order update only ☐

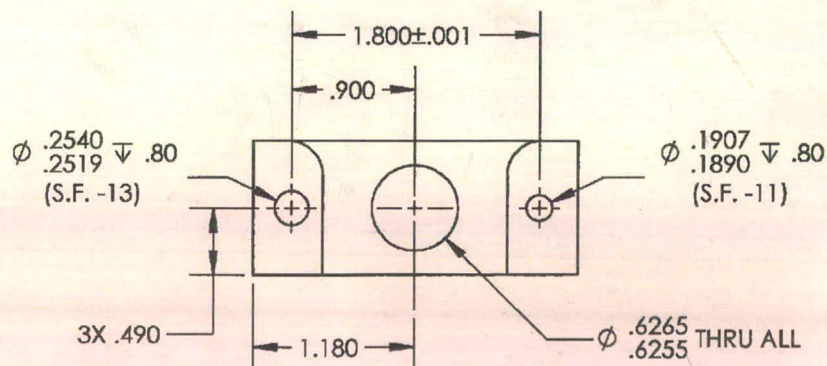
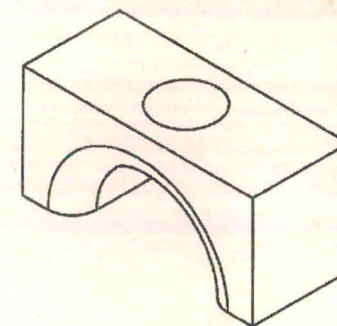
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
250670								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185464 MWS
18-10-24



SECTION B-B



(3)

TOP

DART AEROSPACE	
TITLE: PRESS IN/PUSH OUT DEVICE	
DWG NO. RBE1120-31502W1-3	REV 1
MAT'L A36/1018/1020 HR HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES XX ± .005 FRACTIONS ± 1/8 XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: [Signature] CHECKED: [Signature] OPPTS APPR: [Signature] QA APPR: [Signature] APPROVED: [Signature]	
USED ON MODEL EC145, EC645	
SCALE 3:4	DATE 09/12/2016 SHEET 3 OF 6



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042024

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042024
PO Date: 12/12/18
Due Date: 12/19/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187620	RB T103140-101-1	Plate Assembly -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	12/19/18	2 pcs	0 pcs	2 pcs	\$45.00/pcs	\$90.00
					2x	DEC 18 2018					
2	185463	RBE1120-31502W1-1	Base -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	12/19/18	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
					2x	DEC 18 2018					



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PURCHASE ORDER **PO042024**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185464	RBE1120-31502W1-3	Top -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	12/19/18	2 pcs	0 pcs	2 pcs	\$0.01/pcs	\$0.02
						2 X		DEC 18 2018			
											DAS 38 9-89
4	184975	RBW6305G01052-3G	Wrench, Main Gear Box Oil Pump Ring Nut Removal/Install -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/19/18	6 pcs	0 pcs	6 pcs	\$0.11/pcs	\$0.66
						6 X		DEC 18 2018			
Grand Total:											\$90.70

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/18/18 6:10 AM dart.belanger.natasha



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

015336-1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
15-Dec-2018		Ross Montieth		042024 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT103140-101-1 ✓ Rev.	RBT103140-101-1 01 - ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	2	2 ✓	0	0	0
2	RBE1120-31502W1-1 ✓ Rev.	RBE1120-31502W1-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	2	2 ✓	0	0	0
3	RBE1120-31502W1-3 ✓ Rev.	RBE1120-31502W1-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	2	2 ✓	0	0	0
4	RBW6305G01052-3G ✓ Rev.	RBW6305G01052-3G 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	6	6 ✓	0	0	0

DAS
38
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

